

20-7887



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

UNDER REVIEW

SAP IT
20.01.23

D3319-1

Job Sheet 205350



POSITIVE RECALL

EFFECTIVE 5/20/17 AUTH SAK
RELEASED 9-89 DATE 20-01-23

Part No: D3319-1

Job Qty: 2 pcs

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/8/20

Job Tracking No:

Due Date: 1/24/20

Created By: Jennifer Renwick

Type: SOLD

Description: For customer Support

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D
17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2		1/24/20	0.17	0.21	Waterjet - Flow		SRB 1/14/20
		pcs					Waterjet - Omax		
110	QC 2	2		1/24/20	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

Date: 01/14/20

PRIORITY

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospa.com



Container No: S247399

Part: D3319-1

Job No: 205350

Serial No/Batch: S247399

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Plex 1/8/20 9:47 AM Dart.Renwick.Jennife

1/8/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

120 QC 8	2 pcs	1/24/20	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	SRB 1/14/20
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
140 Small Fab - Brake NC - B4B	2 pcs	1/24/20	0.25 0.14	QC 8 - 1 (A)	
				QC 8 - 47	DAS 40 9-89
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	JAN 14 2020
				QC 8 - 76	
				QC 8 - 61	
				Small Fab - Brake - 1 - B4B	DAS 30 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	2 pcs	1/24/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 9-89
				QC 5 - 61	
				QC 5 - 81	
160 Automated Welding - B4B	2 pcs	1/24/20	0.00 0.51	Automated Welding - 1 - B4B	MW
170 QC 10	2	1/24/20	0.00 0.00	QC 10 - 10	

DAS
82
9-89

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1/8/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

	pcs			QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	EL
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
180 QC 5	2	1/24/20	0.00 0.00	QC 5 - 10	
	pcs			QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	68-8
190 Spray Paint - 2 - B4B	2	1/24/20	0.00 0.33	Spray Paint - 1 - B4B	JAN 22 2020
	pcs			Spray Paint - 2 - B4B	DAS
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 3	2	1/24/20	0.00 0.00	QC 3 - 10	
	pcs			QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	DAS
				QC 3 - 59	40
				QC 3 - 68	9-89
				QC 3 - 9	
				QC 3 - 40	JAN 23 2020
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
210 Packaging 3-1 - Stock - B4B	2	1/24/20	0.00 0.00	Packaging 3 - 1 - B4B	JR
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	

POSITIVE
RECALLDAS
9 20-01-23
9-89See
Ors for
test fitDAS
40
9-89DAS
82
9-89

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
220 QC 21 - SA	2 pcs	1/24/20	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	JAN 23 2020
					QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: E1 Prog Rev: E1 2-Debur if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - QC8- Inspect parts - second check)
 140 - (Form as per dwg) 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: E1 2- Form flat on press using DT8776 block
 150 - QC5- Inspect part completeness to step on W/O)
 160 - 8259 HARDCOAT B: 19139126
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - Spray Paint / NDT Room) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE. BATCH: 5242921
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location: _____)Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

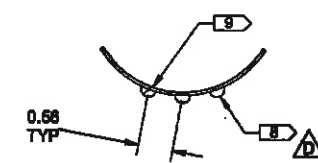
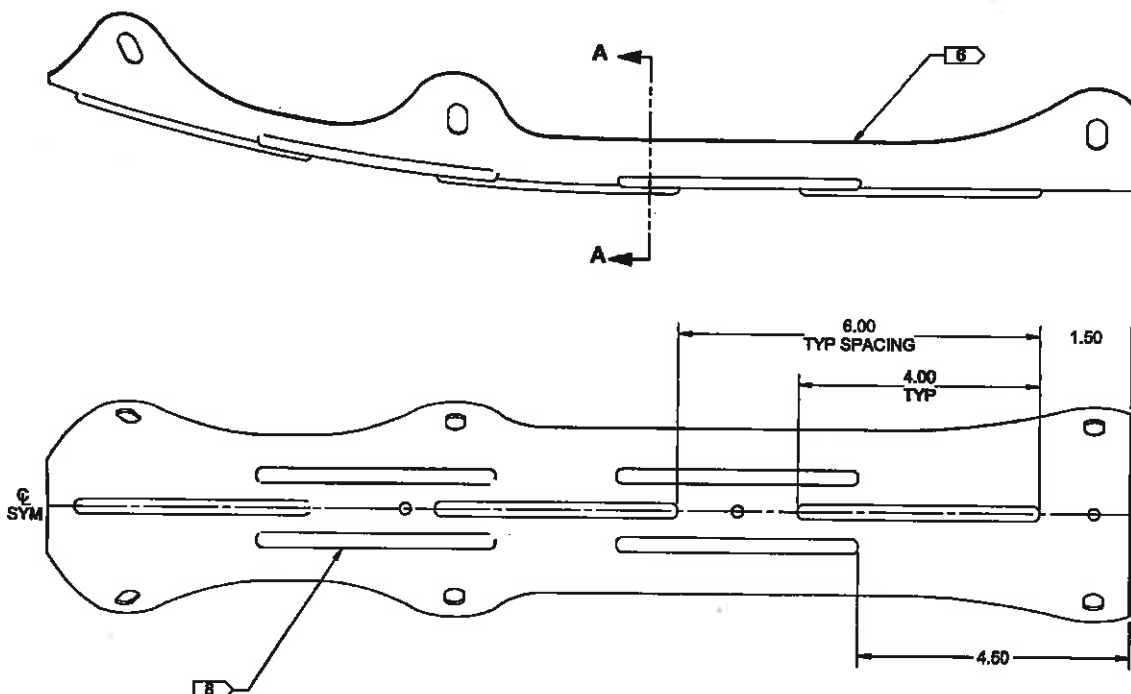
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	1.2560 sf (.628 ea)	100-Waterjet - Flow - 1	5227406

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	1	758	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches $\pm$ 0.030	5.010 4.950		
2	Wearplate	1.600inches $\pm$ 0.010	1.610 1.590		
3	Wearplate	2.660inches $\pm$ 0.010	2.670 2.650		
4	Wearplate	3.190inches $\pm$ 0.010	3.200 3.180		
5	Wearplate	3.563inches $\pm$ 0.010	3.573 3.553		
6	Wearplate	4.710Inches $\pm$ 0.030	4.740 4.680		
7	Wearplate	0.600inches $\pm$ 0.030	0.630 0.570		
8	Wearplate	10.576inches $\pm$ 0.010	10.586 10.566		
9	Wearplate	11.942inches $\pm$ 0.010	11.952 11.932		
10	Wearplate	18.090inches $\pm$ 0.030	18.120 18.060		
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315		
12	Wearplate	0.546inches $\pm$ 0.010	0.556 0.536		
13	Wearplate	0.316Inches + 0.006 - 0.001	0.322 0.315		
14	Wearplate	0.670inches $\pm$ 0.010	0.680 0.660		
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
16	Wearplate	3.815inches $\pm$ 0.010	3.825 3.805		
17	Wearplate	16.100inches $\pm$ 0.010	16.110 16.090		

Plex 1/8/20 9:47 AM Dart.Renwick.Jennifer



SECTION A-A

D3319-1 WEARPLATE
MAKE FROM D3319-1BND

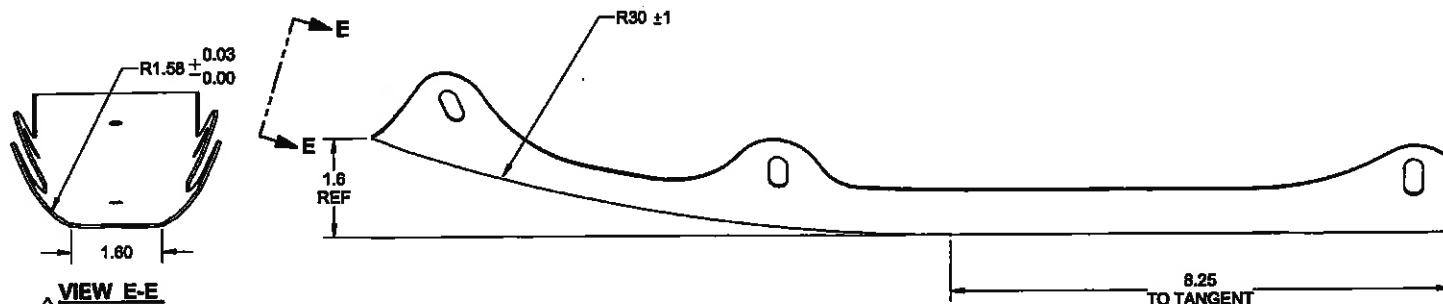
RELEASED
2017 AUG 10
REV 17.414

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-1" PER QSI 044 6.1
 - 7) WEIGHT: 1.09 lbs
 - 8) BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

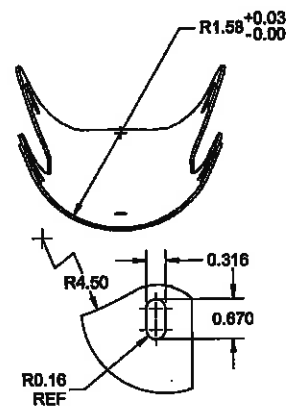
REV.	DESCRIPTION		BY	DATE
	D	REVISE DRAWING TO SOLIDWORKS FORMAT, UPDATE NOTES, ADD ROBOTIC WELDING PROCESS, UPDATE TOLERANCES TO REFLECT INSPECTION CAPABILITY, CHANGE DRAIN HOLE LOCATION D3319-1, 12.00 WAS 12.000 (ZN B6-2), CHANGE WELD, PATTERN AND ADD MISSING DRAIN HOLES D3319-1/3, CHANGE MTL TO S8 304/316, ADDED D3319-1BND SECTION VIEW F-F, AND UPDATED VIEW E-E ADDED DETAIL D, I, P	SAD	17.05.09
	C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFTMOST HOLE OF -3/4-7 (REF DETAIL C) SEE NCR 12-647	MB	12.03.13
	B	WIDEN HOLES, REDUCE WIDTH OF -3/4-7	PH	05.08.08
A		NEW ISSUE	PH	04.08.24
DESIGN	PH	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA		
DRAWN	SAD			
CHECKED	AJS	DRAWING NO.		REV. D
MFG. APPR.	DP	D3319		SHEET 1 OF 8
APPROVED	WM	TITLE		SCALE
DE APPR.	DS	WEARPLATE		NTS
DATE		17.05.09		

APPROVED

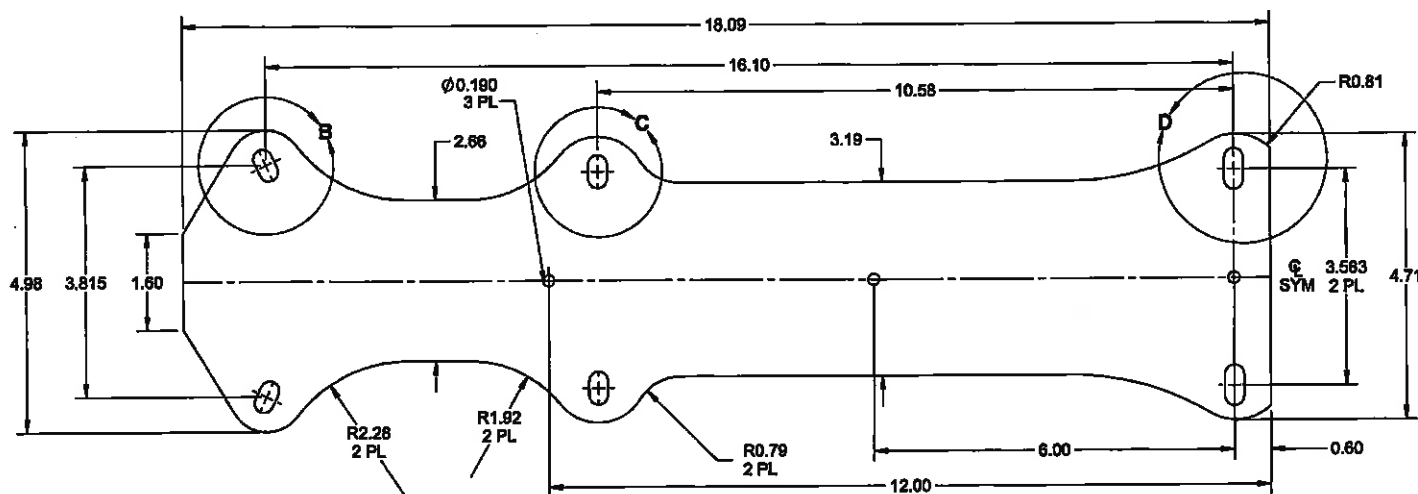
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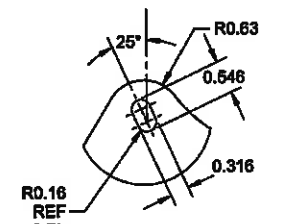
D3319-1BND WEARPLATE
MAKE FROM D3319-1F



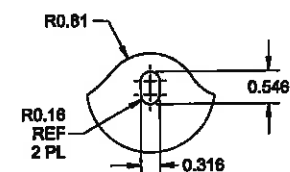
DETAIL D
2 PL



D3319-1F WEARPLATE
FLAT PATTERN



DETAIL B
2 PL



DETAIL C
2 PL

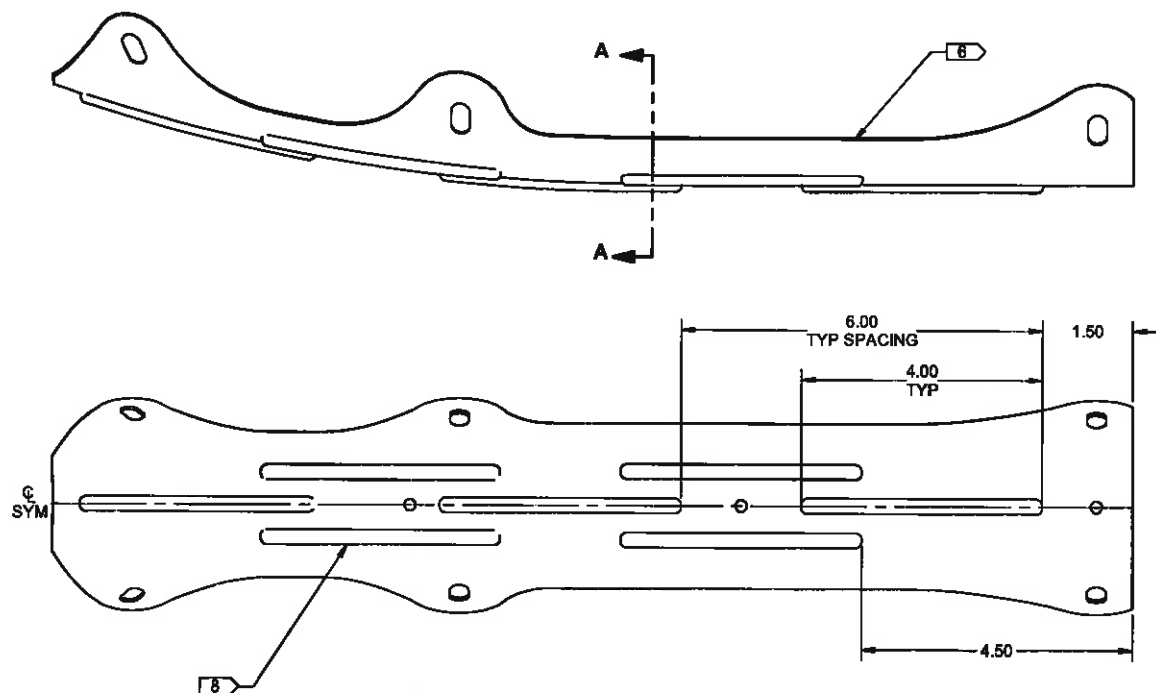
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 18 GAUGE (0.048 THICK)
PER MIL-S-6059 OR AMS 5513 (304)
OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.84 lbs
- 8) FOR NON-DIMENSIONED FEATURES, REFER TO CAD FILE D3319-1F-REV.DJXF

RELEASED
2017 AUG 10

APPROVED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DP	D3319	SHEET 2 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	17.05.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



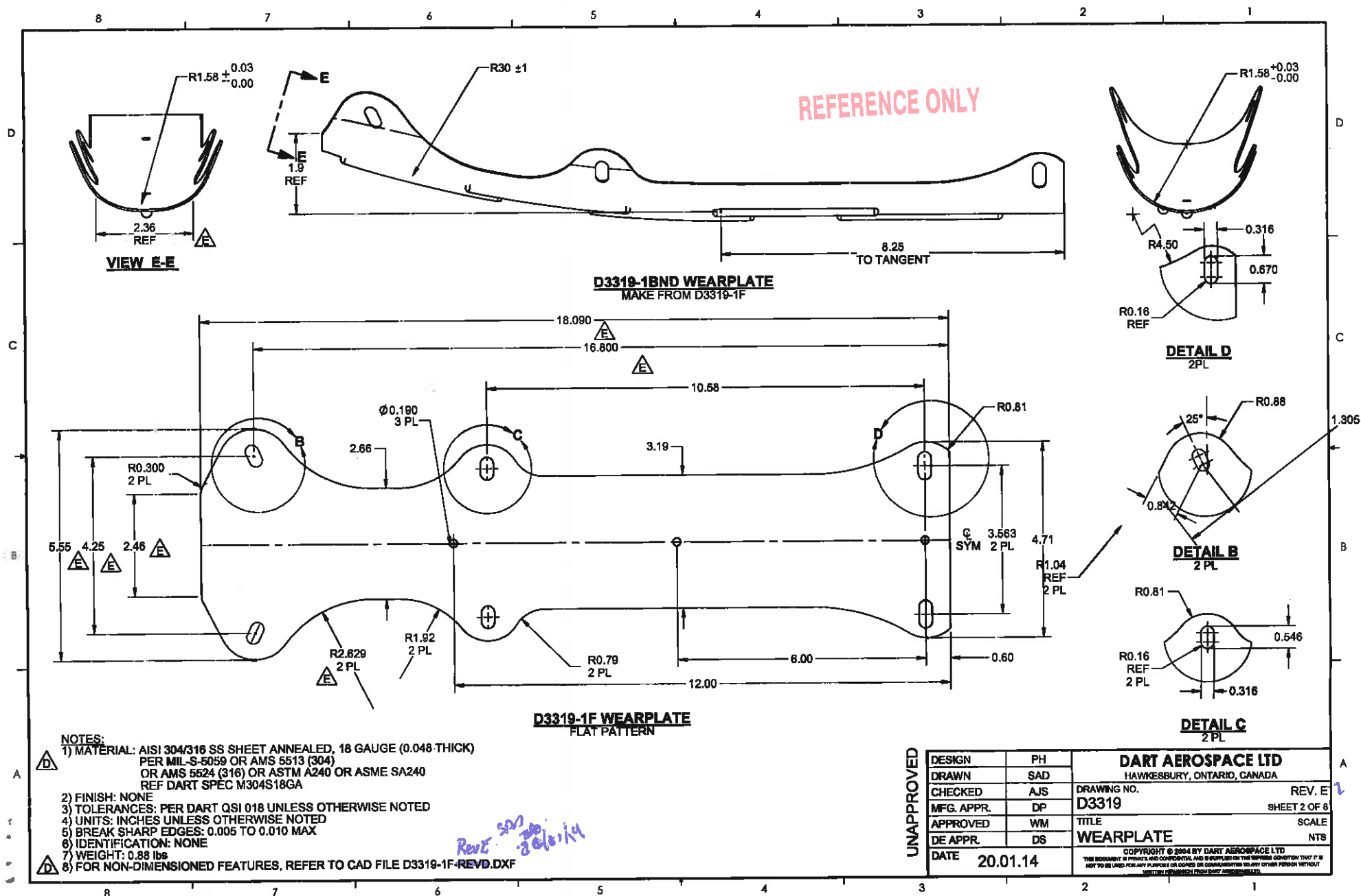
D3319-1 WEARPLATE
MAKE FROM D3319-1BND

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-1" PER QSI 044 6.1
- 7) WEIGHT: 1.39 lbs
- 8) BUILDUP HARD SURFACING 0.08 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.08 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

E	REVISED D3319-1F	SAD	20.01.14
D	REVISE DRAWING TO SOLIDWORKS FORMAT. UPDATE NOTES, ADD ROBOTIC WELDING PROCESS, UPDATE TOLERANCES TO REFLECT INSPECTION CAPABILITY, CHANGE DRAIN HOLE LOCATION D3319-1, 12.00 WAS 12.800 (ZN B8-2), CHANGE WELD, PATTERN AND ADD MISSING DRAIN HOLES. D3319-1-3, CHANGE MTL TO SS 304/316, ADDED D3319-1BND, SECTION VIEW F-F, AND UPDATED VIEW E-F. ADDED DETAIL D, I, P.	SAD	17.05.09
C	UPDATE TO CURRENT STANDARDS IAW QSI 043: CLOSED AFTMOST HOLE OF -3/-5/-7 (REF DETAIL G) SEE NCR 12-547	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH OF -3/-5/-7	PH	06.08.08
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3319 REV. E SHEET 1 OF 8 TITLE WEARPLATE SCALE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND UNCLASSIFIED. IT IS TO BE KEPT IN CONFIDENCE AND NOT TO BE RELEASED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	SAD		
CHECKED	AJS		
MFG. APPR.	DP		
APPROVED	WM		
DE APPR.	DS	DATE 20.01.14	

UNAPPROVED



Feb 10/2020



20-7887

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>2055 205350</u> Part No. <u>D3319-1</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier Quality ☐			
Date : <u>20-01-23</u>		Sequence #: <u>100</u>		QTY Affected : <u>1</u>		MRB (QSI042) DAS 5120/01/14 9-89	
Description Work Order Deviation				Disposition		Completed By DAS 5120/01/14 9-89	
minor deviation to Drawing dimension for D3319-1F Rev. D, Following Drawing D3319-1F Rev. E USE UPDATED DXF D3319.1F REV E For Flat Pattern the Following Dimension will change 16.16 → 16.800 1.60 → 2.46 3.815 → 4.25 4.98 → 5.55				Acceptable to use deviated Dimension on Drawing DXF D3319-1F Rev. E TEST FIT DONE ON C641 350 from DART		Lead hand / Supervisor DAS 9 20-01-23 9-89	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☒ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐			
Other/Details:							